

Work Order ID 64185

Monday, November 29, 2010 3:29:58 PM



Page 1

Item ID: D2221

Accept



Setup Start



Revision ID:

Item Name: 350 Basket Base

Stop



Start Date: 11/29/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 12/7/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10-11-30

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2221

Rev H

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs and both D2581 in DT9444 jig, weld as per 'dwg D2221
2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per
dwg D2221
3- tack weld mesh on basket as per dwg D2221
A/R ER316 S.S. Rod Batch: 4114649

Cpl 10-12-08

PLEASE NOTE

IF MAKING -041A OR -043A :
DRILL HOLES FOR GAS SPRING
IN D3825-041 AS PER
DSI 9473

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

BE 10-12-06

1 [Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Required Date: 12/7/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

125

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

1 BL 10/12/06

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

M118951.

Memo

0.00

Powder Coating

1- Plug holes prior to

1ST COAT:

START TIME: *1:45*

OVEN TEMPERATURE: *400*

FINISH TIME: *2:15*

***** 2nd coat if necessary*****

2ND COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

1 BL 10-12-6

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

ES 10/12/07 (D)

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Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: *GA*

0.00



Packaging

Memo

W/064187

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*EP 10/12/07 @**10/12/07**MF 10-12-07*

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Monday, November 29, 2010 3:30:02 PM

Page 1

A 10x10 grid of 100 small, identical images of a barcode. Each image is a standard 1D barcode with vertical black bars of varying widths on a white background. The grid is arranged in 10 rows and 10 columns.









Start Date: 11/29/2010 **Required Date:** 12/7/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J 05.09.02 Added D3442-1 ☐ KJ/JLM
 IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC
 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:EC IPP Rev:N
 10.06.29 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1 		Manufactured	No			100	Each	16.0000	1	1			
Rib										<i>MS</i> 10/12/01			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				16					
				61424				1					
				62519				3		<i>1x</i>			
				63628				12					
D2221-5 		Manufactured	No			100	Each	6.0000	2	2			
Rib										<i>MS</i> 10/12/01			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				6					
				62996				6		<i>2x</i>			
D2221-7 		Manufactured	No			100	Each	3.0000	1	1			
Rib										<i>MS</i> 10/12/01			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				3					
				62997				3		<i>1x</i>			

W/O:		WORK ORDER CHANGES					
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Picklist Print

Monday, November 29, 2010 3:30:02 PM

Work Order ID: 64185

Parent Item: D2221

Parent Item Name: 350 Basket Base

Start Date: 11/29/2010

Required Date: 12/7/2010

Start Qty: 1.00

Required Qty: 1.00

D2232-3

Manufactured No

100 Each

6.0000

2

2



Basket Hinge



10/12/01

Location

Loc Qty

Loc Code

WA

6

63878

6

2x

D2235-1

Manufactured No

100 Each

10.0000

2

2



Basket Rib



10/12/01

Location

Loc Qty

Loc Code

WA

10

64109

10

2x

D2581

Manufactured No

100 Each

23.0000

2

2



Mounting Bracket



10/12/01

Location

Loc Qty

Loc Code

WA

23

61953

20

2x

63493

3

D3442-1

Manufactured No

100 Each

14.0000

2

2



Shim



10/12/01

Location

Loc Qty

Loc Code

WA

14

61181

2

63002

12

2x

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D2221

Parent Item Name: 350 Basket Base

Start Date: 11/29/2010

Required Date: 12/7/2010

Start Qty: 1.00

Required Qty: 1.00

D3825-041	Manufactured	No	100	Each	6.0000	2	2
Rib Assembly (Basket End)							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	6	
63425	6	

D3826-041	Manufactured	No	100	Each	6.0000	2	2
Rib / Gusset Assembly							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	6	
63119	6	

D3827-041	Manufactured	No	100	Each	3.0000	1	1
Rib Assembly (Inboard)							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	3	
62993	3	

D3832-1	Manufactured	No	100	Each	2.0000	1	1
Mesh (Base)							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	2	
63227	2	

D3833-1	Manufactured	No	100	Each	10.0000	2	2
Mesh (Base End Face)							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	10	
63255	10	

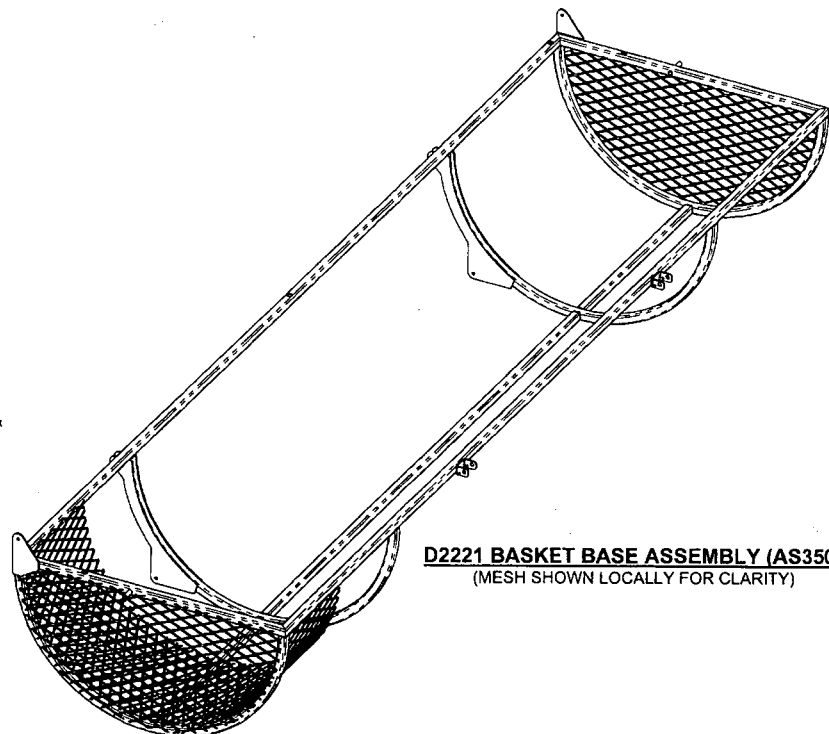
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D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D221-1-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3832-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

RECEIVED
08/11/18

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 64785

22/08/20

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/5/7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL. TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JS		
CHECKED	JS	DRAWING NO.	REV. H
MFG. APPR.	JS	D2221	SHEET 1 OF 5
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

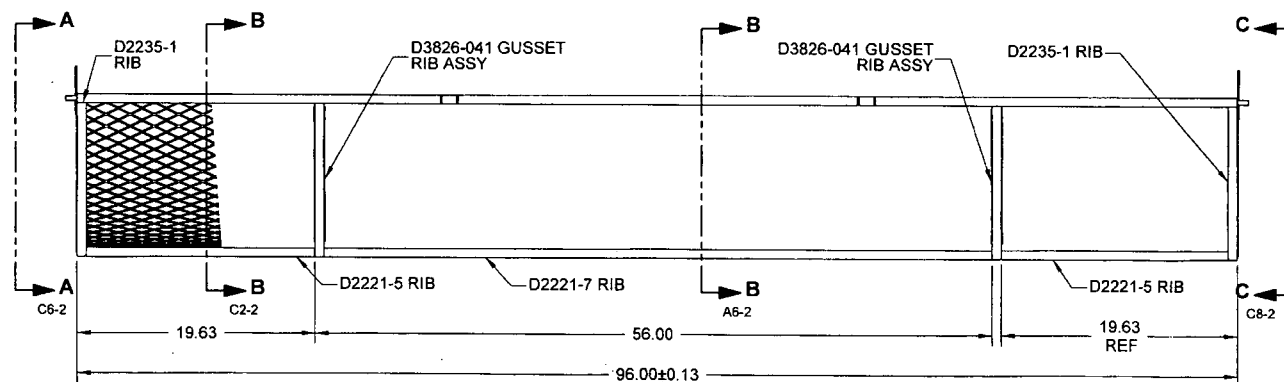
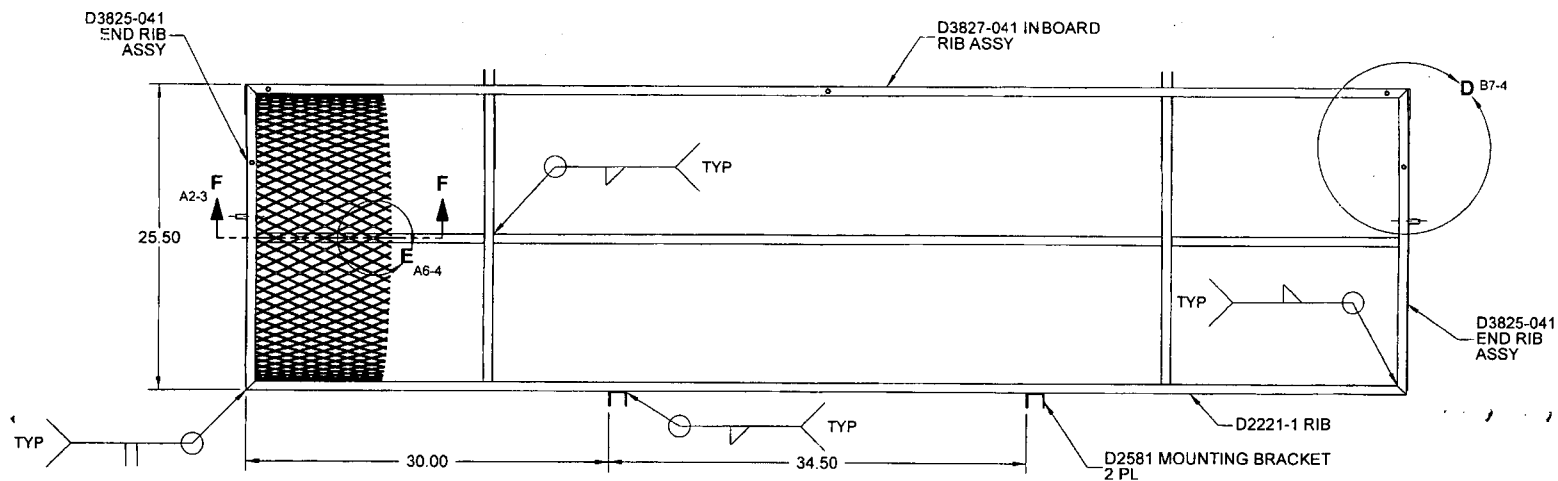
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NOTE: Date & initial all entries



D2221 BASKET BASE ASSEMBLY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
06/11/18 NED

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS TO BE SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

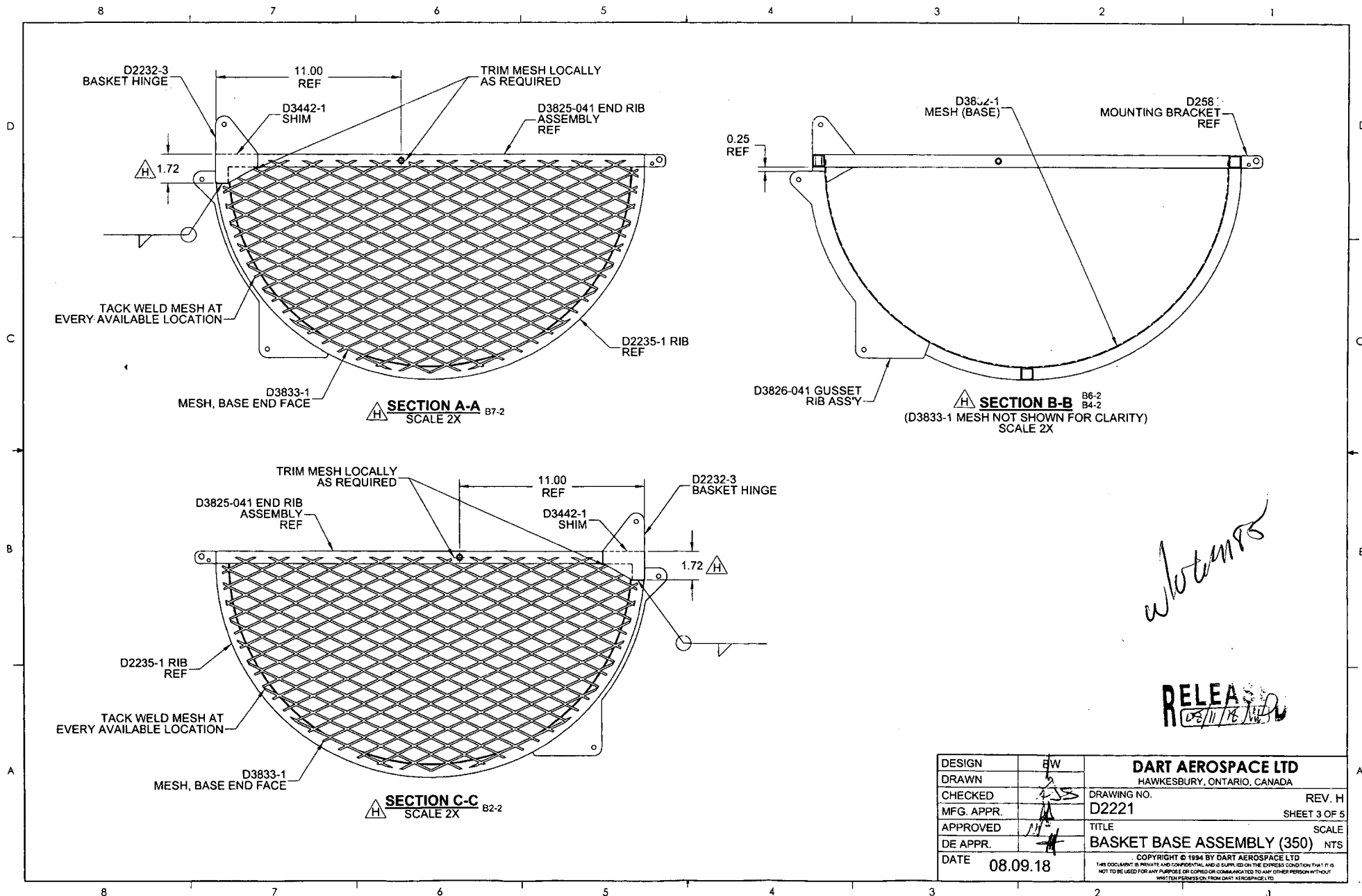
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NOTE: Date & initial all entries



whitman

RELEASED
03/11/16

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	JS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. H
MFG. APPR.	JS	D2221	SHEET 3 OF 5
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	BASKET BASE ASSEMBLY (350) NTS	
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR COMMUNICATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

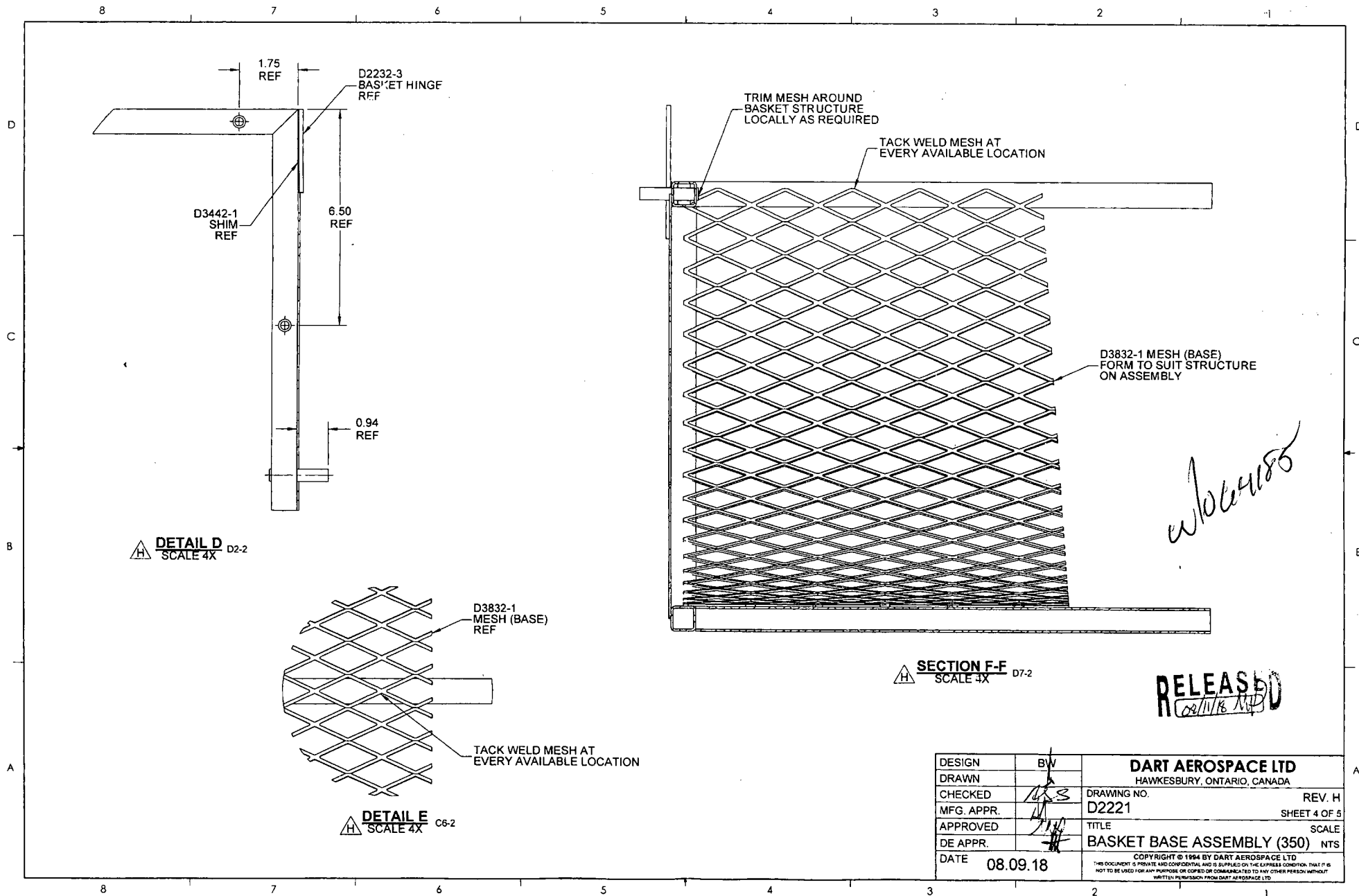
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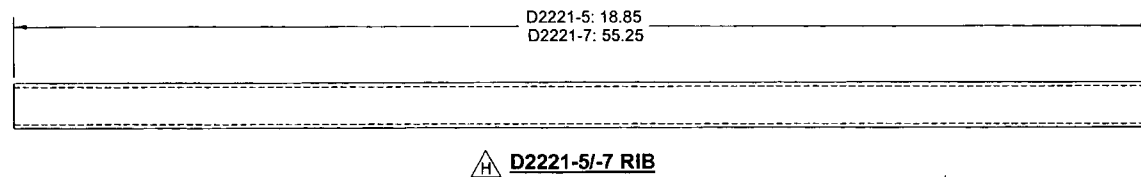
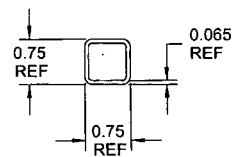
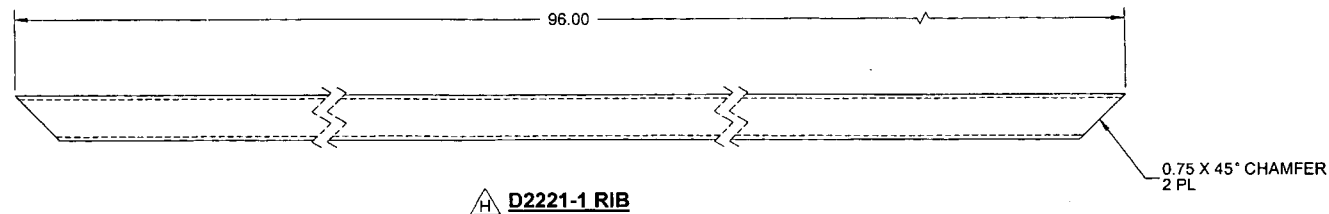
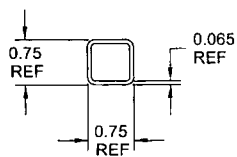
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W044185

RELEASED
08/11/18

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	
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